

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003935**Date Inspected:** 20-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** OBG and SAS Tower Fabrication**Summary of Items Observed:**

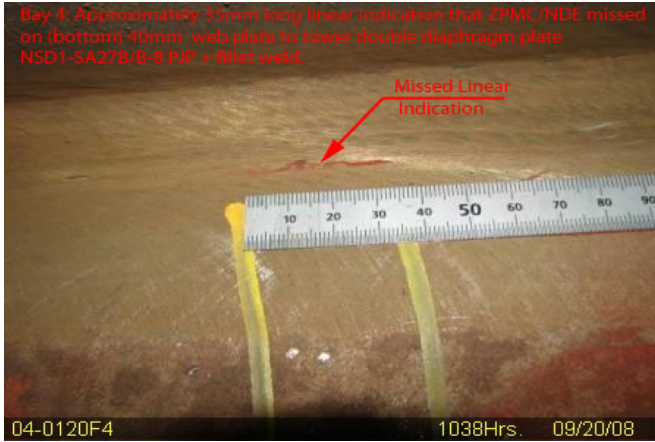
On this date, Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector Joselito Lizardo was present as requested to perform observations on the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China.

This QA observed ZPMC/NDE perform MT on the following weld joints. This QA also performed 10% MT on the same weld joints.

- a) BP-144-001-007~018 - OBG Bottom Plate fillet welds, found deem acceptable
- b) BP117-001-007~018 - OBG Bottom Plate fillet welds, rejected due to 1-transverse linear indication found by ZPMC/NDE
- c) NSD1-SA335-11 - found deem acceptable
- d) NSD1-SA335-12 - found deem acceptable
- e) NSD1-SA335-15 - found deem acceptable
- f) NSD1-SA27B/B-15 - found deem acceptable
- g) NSD1-SA27B/B-4 - found deem acceptable
- h) NSD1-SA27B/B-8 - rejected due to 35mm linear indication found by this QA. Due to this missed indication by ZPMC/NDE, an incident report was issued against ZPMC. See photo below.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, (858) 232-7081, who represents the Office of Structural Materials for your project.

Inspected By:	Lizardo, Joselito	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
